

Work Order ID 77719

77719

Page 1

December-19-11 8:24:17 AM

Item ID: D205-778-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Comfort Seat, LH/RH
 Start Date: 19/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 02/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/12/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3800	B								
DSI 9508	A								
IIN D205-778	Rev B								

100 DOCUMENT CONTROL 0.00
100
 DC Memo 0.00
 Document Control Photocopy bluefile & type labels per PPP D205-778-011 CHG 003 5/12/27
JJ ab MLJ 11-12-21
(2)

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging
11/12/20 SL(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77719

December-19-11 8:24:17 AM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 19/12/2011 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 02/01/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC4- 100% Inspect kits for completeness

0.00

120

0.00

QC

Memo

Quality Control

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-778-101

Location:

PPP Rev: 0

140

QC21- Final Inspection - Work Order Release

0.00

140

OC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-19-11 8:24:21 AM

Page 1

Work Order ID: 77719

77719

Parent Item: D205-778-011

D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
per DSI 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD6L *AN960JD6L* Washer		Purchased	No			110	Each	822.0000	16	32			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST337A				822					
				5519				822					
BSP-42 *BSP-42* Rivet		Purchased	No			110	Each	88.0000	8	16			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST284				88					
				114598				88					
D3752-1 *D3752-1* Seat Frame		Manufactured	No			110	Each	3.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST252A				3					
				73076				3					
D3755-041 *D3755-041* Seat Cushion		Manufactured	No			110	Each	6.0000	3	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST252A				6					
				71183				2					
				73157				4					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-19-11 8:24:21 AM

Work Order ID: 77719

77719

Parent Item: D205-778-011

D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 2.00

Required Qty: 2.00

D3756-041

Manufactured No

110

Each

7.0000

D3756-041

Cushion

**

Location

Loc Qty

Loc Code

ST252A

2

71184

2

ST258A

5

73158

5

D3758-041

Manufactured No

110

Each

21.0000

D3758-041

Clamp

**

Location

Loc Qty

Loc Code

ST081

21

58262

1

73159

20

D3777-041

Manufactured No

110

Each

18.0000

D3777-041

Clamp

**

Location

Loc Qty

Loc Code

ST081

18

73160

18

D3800-3-200

Manufactured No

110

f

120.5000

D3800-3-200

Hook and Loop Strip (2" Hard)

**

Location

Loc Qty

Loc Code

ST083

120.5

56393

60.5

60044

60

1-Cut to length as per dwg (4x 6.00")

→ Measure
Sub 12/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-19-11 8:24:22 AM

Work Order ID: 77719

77719

Parent Item: D205-778-011

D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 19/12/2011

Required Date: 02/01/2012

Start Qty: 2.00

Required Qty: 2.00

~~AN525-10R8~~

Purchased

No

110

Each

121.0000

AN525-10R8

Screw

**

Location

Loc Qty

Loc Code

ST345

121

114494

21

119307

100

Purchased

No

110

Each

67.0000

AN970-3

Washers

**

Location

Loc Qty

Loc Code

ST344

67

117395

42

119531

25

Purchased

No

110

Each

0.0000

~~AN960JD10~~

NAS1149D0363J

AN960JD10

Washer

**

~~MS21042L3~~

Purchased

No

100

Each

7,008.000

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

7008

117441

16

117885

32

118451

5

118927

3

119017

5994

119075

958

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37
REF FAA STC: SR02704NY
REF EASA STC: EASA.IM.R.S.01518

5
REFERENCE ONLY

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	13	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED	11	TITLE	SCALE
DE APPR.	11	RIVET KIT	NTS
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